

Work Order ID 62146

Friday, September 17, 2010 10:16:17 AM



Page 1

Item ID: D3574-2

Accept



Setup Start



Revision ID:

Item Name: Cabin Floor Protector

Stop



Start Date: 9/17/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/17/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: WT

Date: 10-9-17

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3574	Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

FLOW CNC Waterjet

1-Cut as per Dwg D3574 Dwg Rev: B Prog Rev: B 2-
Deburr if necessary

E 10.09.17 ①

110

QC2- Inspect parts off machine FAI/FAIB

0.00



Memo

QC

Quality Control

E 10.09.17 ①

120

QC8- Inspect parts - second check

0.00



Memo

QC

Quality Control

0.00 Solotek

(X) _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D35574-2 PAR #: Fault Category: Small Fabs / w/ Jet NCR: Yes No DQA: Date: 10/05/17
 Resolution: Acceptable Disposition: use as is QA: N/C Closed: Date: _____

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10.09.17	1	Holes are under tol. by 0.008", ran out of sand thru progs. QC process	QP 10.09.17 PS/042	Acceptable	QP 10.09.17 S 10.09.17	QP 10.09.17 S 10.09.17	PS/042	PS/042

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 62146

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Friday, September 17, 2010 10:16:17 AM

Item ID:	D3574-2		Accept		Setup	Start	
Revision ID:					Stop		
Item Name:	Cabin Floor Protector					Stop	
Start Date:	9/17/2010	Start Qty:	1.00		Cust Item ID:		
Required Date:	9/17/2010	Req'd Qty:	1.00		Customer:		
Reference:							
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
					Stop		
	QC:	Date:	SPC (Y/N):	Date:			

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							100517 MP 10-9-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 1

Friday, September 17, 2010 10:16:16 AM

Work Order ID: 62146



Parent Item: D3574-2



Parent Item Name: Cabin Floor Protector

Start Date: 9/17/2010

Required Date: 9/17/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev :A New Issue 07-01-22 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No		M115261		sf	2,251.723	33.6	33.61681			

GE PLASTICS LEXAN SHEET



Location	Loc Qty	Loc Code
MAT	2251.7238	
114032	216.9238	
115261	2034.8	

10.09.17

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	62146
Description: Cabin Floor Protector		Part Number:	D3574-2
Inspection Dwg: D3574	Rev: B		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	2.991		✓	vern	See Dwg Page 2
7.37	+/-0.030	7.37	✓		Tape	EC-11
10.75	+/-0.030	10.75	✓		Tape	
11.00	+/-0.030	11.00	✓		"	
15.25	+/-0.030	15.25	✓		"	
25.87	+/-0.030	25.87	✓		"	
39.75	+/-0.030	39.75	✓		"	
44.75	+/-0.030	44.75	✓		"	
53.51	+/-0.030	53.51	✓		"	
63.50	+/-0.030	63.50	✓		"	
65.25	+/-0.030	65.25	✓		"	
10.75	+/-0.030	10.75	✓		Tape	EC-11
11.00	+/-0.030	11.00	✓		"	
14.75	+/-0.030	14.75	✓		"	
25.50	+/-0.030	25.50	✓		"	
25.75	+/-0.030	25.75	✓		"	
26.00	+/-0.030	26.00	✓		"	
32.87	+/-0.030	32.87	✓		"	
38.81	+/-0.030	38.81	✓		"	
45.00	+/-0.030	45.00	✓		"	
48.25	+/-0.030	48.25	✓		"	
58.38	+/-0.030	58.38	✓		"	
61.25	+/-0.030	61.25	✓		"	
64.13	+/-0.030	64.13	✓		"	
64.63	+/-0.030	64.63	✓		"	
66.50	+/-0.030	66.50	✓		"	
7.50	+/-0.030	7.50	✓		Tape	EC-11
9.50	+/-0.030	9.50	✓		"	
10.38	+/-0.030	10.38	✓		"	
10.88	+/-0.030	10.88	✓		"	
14.50	+/-0.030	14.50	✓		"	
16.56	+/-0.030	16.56	✓		"	
18.75	+/-0.030	18.75	✓		"	
24.13	+/-0.030	24.13	✓		"	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	82146
Description: Cabin Floor Protector		Part Number:	D3574-2
Inspection Dwg: D3574 Rev: B		Page 2 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
26.50	+/-0.030	26.50	—	—	Type EC-11	
30.50	+/-0.030	30.50	—	—	4	
33.88	+/-0.030	33.88	—	—	4	
39.50	+/-0.030	39.50	—	—	4	
40.25	+/-0.030	40.25	—	—	4	
43.50	+/-0.030	43.50	—	—	4	
46.60	+/-0.030	46.60	—	—	4	
7.63	+/-0.030	7.63	—	—	Type EC-11	
11.00	+/-0.030	11.00	—	—	4	
11.50	+/-0.030	11.50	—	—	4	
16.75	+/-0.030	16.75	—	—	4	
19.00	+/-0.030	19.00	—	—	4	
22.50	+/-0.030	22.50	—	—	4	
30.75	+/-0.030	30.75	—	—	4	
32.63	+/-0.030	32.63	—	—	4	
32.75	+/-0.030	32.75	—	—	4	
35.13	+/-0.030	35.13	—	—	4	
36.50	+/-0.030	36.50	—	—	4	
40.00	+/-0.030	40.00	—	—	4	
41.88	+/-0.030	41.88	—	—	4	
43.63	+/-0.030	43.63	—	—	4	
0.125	+/-0.010	0.125	✓	—	✓ Ver. EC-8	

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	10.09.17	Date:	10.09.17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD	
B	08.07.31	47.75 dimension removed	KJ/DD	
C	09.05.15	Dimensions updated per Dwg Rev B	KJ 	

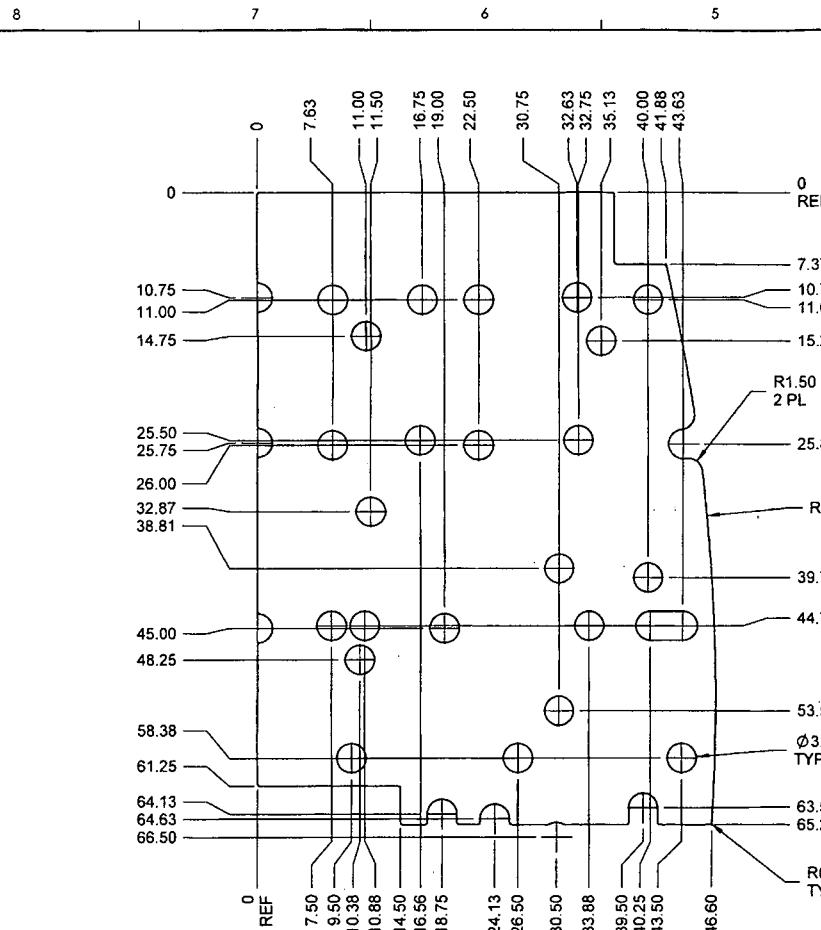
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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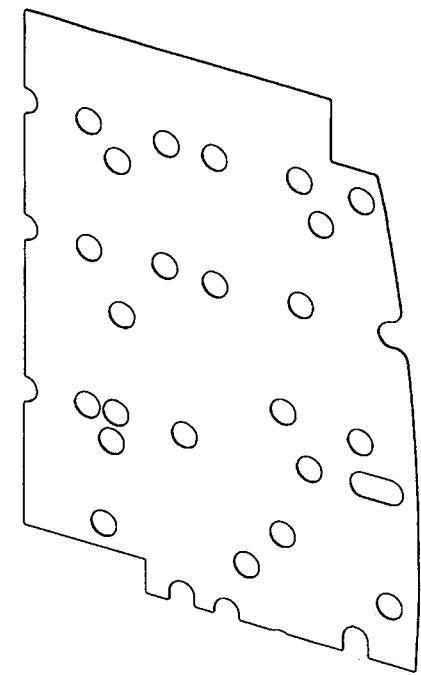


D3574-2 CABIN FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-2" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.30 lbs
- 8) CHECK PER TEMPLATE DT8961

#62146

RELEASED
04/04/01 MHD

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO. D3574
MFG. APPR.	<i>[Signature]</i>	REV. B
APPROVED	<i>[Signature]</i>	SHEET 2 OF 6
DE APPR.	<i>[Signature]</i>	TITLE CABIN FLOOR PROTECTOR
DATE	09.03.25	SCALE NTS

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